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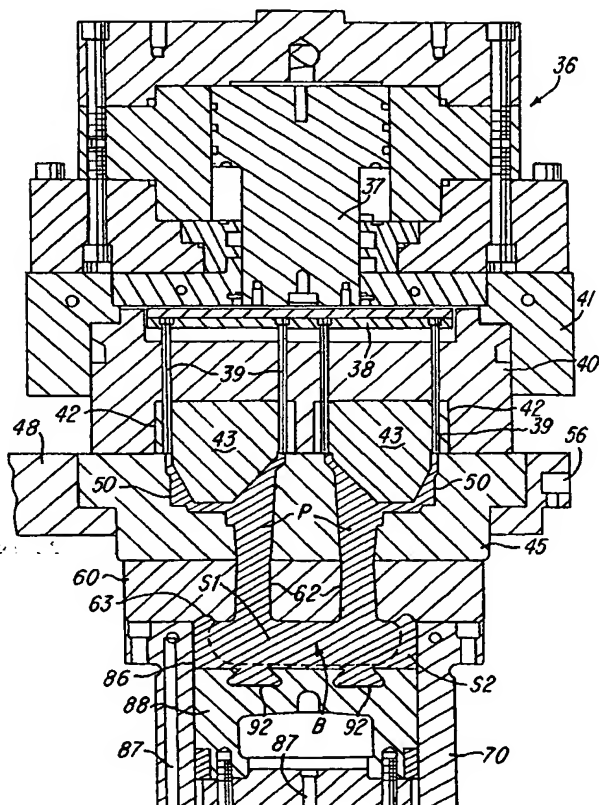
- as to applicant's entitlement to apply for and be granted a patent (Rule 4.17(ii)) for all designations
- as to the applicant's entitlement to claim the priority of the earlier application (Rule 4.17(iii)) for all designations

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[Continued on next page]

(54) Title: SEMI-SOLID MOLDING METHOD



(57) Abstract: A metal alloy is heated to a molten state, and a grain refiner may be added. The refined molten alloy is poured into a large diameter shot sleeve (86) of a vertical die cast press (10) and on top of a shot piston (88). The shot sleeve is transferred to an injection station while the molten alloy cools to a semi-solid slurry with approximately fifty percent solids and a globular, generally non-dendritic microstructure. A center portion (A) of the slurry is injected upwardly by the piston through a gate opening (62) into a die cavity (50) while an outer, more solid portion (S2) is entrapped in an annular recess (63). After the slurry solidifies, the shot piston retracts, and the shot sleeve is transferred to a position where the residual biscuit (B) is removed. A second shot sleeve (86) filled with the molten alloy is transferred to the metal transfer station (82), and the process is repeated.

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For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

SEMI-SOLID MOLDING METHOD

Background of the Invention

[0001] The present invention relates to semi-solid molding (SSM) of metal alloys and the equipment and methods used for SSM, and which are disclosed in many U.S. and foreign patents, for example, in U.S. Patents No. 3,954,455, No. 4,434,837, No. 5,161,601 and No. 6,165,411. SSM is also discussed in technical publications, for example, in a book entitled Science and Technology of Semi-Solid Metal Processing, published by North American Die Casting Association in October, 2001. Chapter 4 of this publication was authored by a co-inventor of the present invention. In conventional SSM processes, it is necessary to use either a specially treated, pre-cast billet of appropriate microstructure or a slurry especially prepared from molten alloy in equipment external to a die casting press. The cost premiums associated with either the pre cast specially treated billet that must be sawed to length before using, or the slurry especially prepared in equipment external to the die casting press, have severely limited the commercial applications of the SSM processes. Also, the pre-cast billet is available from a relatively few sources, is currently made only from primary alloys, and process offal cannot be reused unless reprocessed back into a billet.

[0002] Still, SSM provides some important and highly desirable characteristics. Unlike conventional die castings, die cast parts which are produced using SSM processes can be produced substantially free of porosity, they are able to undergo high temperature thermal processing without blistering, they can be made from premium alloys, and they provide reliable high levels of strength and ductility when made using appropriate alloys and heat treatments. Because of the thixotropic nature of semi-solid slurry and the non-turbulent way that relatively viscous thixotropic slurries flow in die casting dies, the SSM process is capable of producing cast parts having thin sections, great detail and complexity and close dimensional tolerances, without the entrapped porosity and oxides which are commonplace in conventional die casting processes.

Summary of the Invention

[0003] The present invention is directed to a new SSM process or method which significantly reduces the costs of producing parts by the SSM process. The method of the invention is ideally suited for producing parts having thin sections, fine detail and complexity and close dimensional tolerances, and which

are substantially free of porosity and oxides, can be processed at elevated temperatures without blistering and which can provide high and reliable levels of strength and ductility. The method of the invention avoids any need to produce a specially treated, pre-cast billet that must be sawed to length before using or a slurry especially prepared from molten alloy in equipment external to the die casting press. The method of the invention is also applicable to a wide variety of alloys, for example, standard A356 alloy and alloys of the Al-Si, Al-Cu, Al-Mg and Al-Zn families, all of which can be acquired in the form of and at prices normal to conventional foundry ingot, including both primary and secondary origin.

[0004] In accordance with one embodiment of the present invention, an ingot of commercially available solid metal or metal alloy, such as aluminum foundry alloy ingot, is heated to the molten state. If not permanently grain refined, such as by employing a foundry alloy called SiBloy produced by Elkem Aluminum, AS, an α aluminum grain refining material such as 5:1::Ti:B master alloy produced by numerous suppliers, or a product called TiBloy produced by Metallurg, is added to the molten alloy in appropriate quantities to accomplish fine grains in the solidified alloy product. The grain refined molten alloy is poured directly into a large diameter shot sleeve or chamber of a vertical die casting machine or press. The shot chamber receives a vertically movable shot piston which forms the bottom of the shot chamber, and the diameter of the shot chamber is greater than its depth or axial length. In a preferred embodiment of the present invention, the shot chamber is greater than its depth by a ration of 2:1 or more. The shot chamber is then indexed from the initial filling position to a slurry injection position under a die. The molten alloy is permitted to cool within the shot chamber to a predetermined temperature range in which it forms a semi-solid slurry having 40 to 60 percent solid, the solid fraction having a globular, generally non-dendritic microstructure. The portion of the slurry immediately adjacent to the wall of the shot chamber or shot sleeve and the shot piston become significantly colder and more solid.

[0005] When the semi-solid slurry within the central portion of a first shot chamber, now in the slurry injection position under the die, has cooled to the predetermined temperature range in which it has 40 to 60 percent solid, the shot piston is moved upwardly by a mechanical actuator or a hydraulic shot cylinder to transfer or inject the semi-solid slurry within the central portion of the shot chamber through one or more gate or sprue openings and into one or more cavities in the die above the shot chamber. The more solid portion of the slurry

adjacent the shot sleeve is prevented from entering the die cavity or cavities, either by appropriately distancing the gate or sprue openings from the shot sleeve walls or by entrapping the more solid portion within an annular recess in the gate plate through which the gates or sprue openings communicate with the die cavity or cavities. As a result, the more solid portion of the slurry remains in the residual solidified biscuit. After the semi-solid slurry solidifies in the die cavity or cavities, the shot piston retracts to retract the biscuit intact with gates or sprues. The shot chamber is then transferred or indexed back to its initial filling position where the biscuit with the gates is removed laterally from the shot chamber and piston, and the shot chamber is then ready to repeat the cycle. After the die is opened, the part(s) is ejected and then indexed to a position where it is removed, and the die is ready to repeat the cycle.

[0006] During the slurry forming, slurry injection and slurry solidification steps described above relative to the first shot chamber while in its shot position, a second shot chamber in the original filling position has similarly been filled with grain refined molten alloy. When the first shot chamber and its piston are transferred or indexed back to the initial filling position for biscuit removal, the second shot chamber and molten alloy are indexed to the metal transfer or slurry injection position under the die, and the process of slurry formation, slurry injection and slurry solidification is accomplished just as with the first shot chamber. The process is repeated over and over again.

[0007] Other features and advantages of the invention will be apparent from the following description, the accompanying drawings and the appended claims.

Brief Description of the Drawings

[0008] FIG. 1 is a vertical section through a vertical die casting press which is used to perform the method of the invention and with the die set shown in its open position;

[0009] FIG. 2 is an enlarged fragmentary section of the semi-solid slurry transfer or injection position or station shown in FIG. 1 and with the die set shown in its closed position; and

[0010] FIG. 3 is a diagrammatic illustration of the metal temperature profile of the semi-solid slurry before a center portion of the slurry is transferred or injected into the die cavities shown in FIG. 2.

Description of the Preferred Embodiment

[0011] Referring to FIG. 1, a vertical die cast machine or press 10 is constructed similar to the press disclosed in U.S. Patent No. 5,660,223 which issued to the assignee of the present invention and the disclosure of which is incorporated by reference. The press 10 includes a frame 12 formed by a pair of parallel spaced vertical side walls or plates 14 rigidly connected by top plate 16 a base or bottom plate 18 and a set of intermediate cross plates or bars 22 and 24 all rigidly secured to the side panels 14. The top cross plate 16 supports an upper double acting hydraulic clamping cylinder 30 having a piston rod 32 projecting downwardly on a vertical center axis of the press. The piston rod 32 carries an adapter plate 34 which supports a hydraulic ejector cylinder 36 having a piston 37 projecting downwardly to support a plate 38 which carries a set of ejector pins 39.

[0012] An upper die or mold section 40 (FIG. 2) is secured to the bottom of the plate 38 by an annular retaining plate 41 and has a pair of recesses 42 which receive corresponding core members 43. A lower die or mold section 45 is recessed within a circular indexing or transfer table 48 and defines a pair of cavities 50 which cooperate with the core members 43 to define the corresponding metal parts P produced in accordance with the method of the invention. The transfer or indexing table 48 is mounted on a shaft 52 (FIG. 1) supported by a set of bearings 53 retained within the frame member 54. The table 48 carries a plurality of at least two lower mold sections 45 and is rotated or indexed by a pinion (not shown) engaging periphery teeth 56 on the table 48 and driven by a stepping motor (not shown). A gate plate 60 is positioned under the bottom mold section 45 and defines a pair of slightly tapered gates or sprue openings 62, one for each of the cavities 50. The gate plate 60 also defines an annular metal entrapment recess or groove 63. It is to be understood that the parts P to be die cast within the corresponding mold sections 40 and 45 are shown for illustration only and that the configuration or size of the parts form no part of the present invention. The parts P may be any size or shape, corresponding to the desired die cast article.

[0013] A cylindrical vertical column or post 66 is secured to a plate 67 mounted on the base plate 18 and projects upwardly to support a rotatable circular table 68 by a set of anti-friction bearings 69 mounted on a top hub of the post 66. The table 68 supports a plurality or a pair of diametrically opposite cylindrical shot sleeves 70 which have parallel vertical axes. The table 68 is also supported by a set of thrust bearings 72 mounted on the cross bars or

plates 22 and 24. The table 68 also has peripheral gear teeth 74 which engage a pinion (not shown) mounted on a vertical shaft of an electric stepping motor (not shown). Actuation of the stepping motor is effective to index the table 68 in steps or increments of 180° for alternately presenting the pair of shot sleeves 70 between a molten metal receiving or pour station 80 and a metal injecting or transfer station 82 located under the die sections 40 and 45 and in axial alignment with the clamping cylinder 30.

[0014] Each of the shot sleeves 70 defines a cylindrical shot chamber 86 which receives a corresponding shot piston 88. The upper end portion of each shot piston 88 has a pair of laterally extending and tapered dovetail slots 92, and a shot piston rod 94 projects downwardly from each piston 88. Each of the shot sleeves 70 and each of the piston rods 94 is provided with internal passages 87 (FIG. 2) by which cooling fluid or water is circulated through the sleeves and pistons 88 for cooling the molten metal and to form a metal residue biscuit B having integrally connected and upwardly projecting gate pins formed by the gate openings 62.

[0015] A double acting hydraulic shot cylinder 95 is mounted on a spacer plate 96 secured to the base plate 18 under the metal transfer station 82 and in vertical alignment from the axis of the hydraulic clamping cylinder 30. The shot cylinder 95 includes a piston and piston rod 98 which projects upwardly, and a guide plate 99 is secured to the upper end of the piston rod 98. Another double acting hydraulic ejection cylinder 110 is substantially smaller than the cylinder 95 and is mounted on the plate 67 by a spacer block 112. The cylinder 110 includes a piston and piston rod 114 and a guide plate 116 is secured to the upper end of the piston rod 114. A guide rod 118 projects downwardly from the plate 116 and through a guide block 121 mounted on the cylinder 110 to prevent rotation of the plate 116 and piston rod 114. The cylinder 110 is located in vertical axial alignment with each shot sleeve 70 when the sleeve is located at the metal receiving or pouring station 80.

[0016] A pair of opposing retaining or coupling plates 126 are secured to the upper surface of each of the guide plates 99 and 116. Each set of coupling plates defines inner and outer opposing undercut slots for slidably receiving an outwardly projecting circular flange 128 formed on the bottom of each shot piston rod 94. Thus when the table 68 and shot sleeves 70 are indexed in steps of 180°, the shot piston rods 94 are alternately connected or coupled to the piston rods 98 and 114.

[0017] In operation of the vertical die cast machine or press 10 to perform a semi-solid molding method, a commercially available permanently grain refined alloy such as SiBloy foundry ingot produced by Elkem Aluminum AS, or a non-permanently grain refined alloy such as standard A356 aluminum foundry ingot or foundry alloy ingot of the Al-Si, Al-Cu, Al-Mg or Al-Zn families, is heated to a molten state. Preferably, when a melt of non-permanently grain refined alloy is at a predetermined temperature, for example 650°C or higher, an α aluminum grain refining material, for example, a titanium boron master alloy sold under the trademark TiBloy and produced by Metallurg, is added at a preferred melt-to-master alloy ratio according to the manufacturer's recommendations. The grain refinement step is not necessary when utilizing a permanently grain refined alloy such as SiBloy. After the molten grain refined alloy is lowered to a temperature of about 626°C, or within the range of 621°C to 632°C, the molten alloy is poured into the vertical shot chamber 86 located at the pour or fill station 80 above the ejection cylinder 110. Preferably, the shot chamber 86 has a diameter substantially larger than its depth or axial length, for example, a diameter over 6 inches, such as 7 1/2 inches and a depth of less than 6 inches.

[0018] The shot sleeve 70 confining the molten alloy is then indexed to the transfer or injection station 82 while a cooling period occurs. The molten alloy is allowed to cool in the shot chamber 86 to a temperature range that produces a semi-solid slurry having a range of 40% to 60% solid, such as approximately 50% solid and a globular generally non-dendritic microstructure. For example, the A356 aluminum alloy is allowed to cool to a temperature range between 570°C and 590°C for a period of fifteen seconds or more from the time it entered that temperature range to the shot or injection time. When the alloy has cooled to this temperature within the shot chamber 86 at the transfer station 82, the temperature profile of the alloy is close to that shown in FIG. 3 wherein a center portion A of the alloy has a substantially uniform temperature, and the peripheral portion of the alloy adjacent the shot sleeve 70 is significantly cooler due to the cooling effect of the shot sleeve.

[0019] With the mold sections 40 and 45 in their closed position (FIG. 2) by actuation of the cylinder 30, the injection or shot cylinder 95 is actuated to move the shot piston 88 upwardly. This transfers the semi-solid slurry S1 within the center portion A (FIG. 3) of the alloy upwardly through the gate or sprue openings 62 and into the corresponding die cavities 50 to form the parts P which have the desired globular, generally non-dendritic microstructure. The more solidified outer portion of the slurry S2 within the shot chamber adjacent the

sleeve 70 is captured or trapped in the annular recess 63 and prevented from entering the sprue openings 62.

[0020] While the parts P are solidifying within the cavities 50, another charge of molten alloy is poured into the second shot chamber 86 located at the pour station 80. When the parts in the cavities 50 are solidified, the shot cylinder 95 is actuated to retract the piston 88 and the residual solidified alloy material or biscuit B within the shot chamber 86 and to shear the metal within the gate or sprue openings 62 from the parts P at the interface of the lower mold section 45 and the gate plate 60. The residual solidified metal or biscuit B, including the sprues, within the shot chamber 86 is then transferred by indexing the table 68 to either a biscuit removal station or to the metal pour station 80. At this station, the piston 88 is elevated to a level where the biscuit B is ejected laterally by a fluid cylinder (not shown). After the parts P are fully solidified, the upper mold section 40 is retracted upwardly by actuation of the cylinder 30 while the cylinder 36 is actuated to eject or release the parts with the pins 39. The table 48 is then indexed to transfer the parts P to a part removal station where the parts are lifted and removed, for example, by a robot (not shown). The above method steps for semi-solid molding are then repeated for successively molding another set of parts.

[0021] From the drawings and the above description, it is apparent that a method of semi-solid molding of parts with a vertical die casting press in accordance with the present invention, provides desirable features and advantages. For example, the method of the invention provides for producing die cast parts free of porosity and which may be heat treated to provide a reliable high level of strength and ductility. As a result, the parts may have thin wall sections and be lighter in weight and/or may be complex die cast parts having close tolerances. The method also extends the service life of the die sections since the die sections receive less sensible heat because the injected slurry is at a lower temperature than fully molten metal and with less heat of fusion since the slurry is already approximately 50 percent solid when injected. Also, since the die is required to absorb much less heat in the process, the overall cycle time may be decreased to obtain more efficient production of parts.

[0022] The semi-solid molding method of the invention also eliminates the preparation of special billets or special slurries and the substantial cost of the preparation equipment, and enables the reuse of process offal and scrap. That is, by using conventional foundry ingots or ingots of pure metal, which may be grain refined, the method of the invention significantly lowers the cost of input

material for semi-solid molding. As another feature, the large diameter to depth ratio of the shot chamber and the controlled cooling of the shot sleeves and shot piston provide for obtaining the desired cooling and temperature profile of the alloy within the semi-solid slurry S1 in the center portion of the shot chamber. The annular entrapment recess 63 is also effective to prevent the more solidified alloy S2 adjacent the shot chamber wall or sleeve from entering the sprue openings 62 and flowing into the cavities 50. The short stroke of the shot piston 88, which is greater than its diameter, also provides for a broad range of cavity fill rates, for example, when a rapid fill rate is desired for parts having thin wall sections or a slow fill rate is desired for parts having heavy wall sections. The diameter of the shot sleeve and piston are preferably over 6" and may be substantially more, for example, 24" in order to die cast a large diameter SSM part such as a motor vehicle wheel or frame member.

[0023] While the method and form of apparatus herein described constitutes a preferred embodiment of the invention, it is to be understood that the invention is not limited to the precise method and form of apparatus described, and that changes may be made therein without departing from the scope and spirit of the invention as defined in the appended claims. For example, while the vertical die cast press 10 incorporates rotary indexing tables 48 and 68, vertical die cast presses with other forms of transfer means may be used, for example, a reciprocating shuttle table for the bottom die section or a tilting mechanism for a single shot sleeve.

[0024] What is claimed is:

1. A method of producing a high strength metal part within a die cavity defined by a die set mounted on a vertical die cast press including a shot chamber having a generally vertical axis and a shot piston movable axially within the chamber, the method comprising the steps of heating a solid metal to form a molten metal, directing the molten metal into the shot chamber, cooling the molten metal within the shot chamber to within a temperature range forming a semi-solid slurry having a globular and generally non-dendritic microstructure, moving the shot piston upwardly to transfer the semi-solid slurry from the shot chamber through a gate opening into the die cavity, and allowing the semi-solid slurry to solidify within the die cavity to form the metal part.
2. A method as defined in claim 1 and including the step of adding a grain refiner to the metal directed into the shot chamber.
3. A method as defined in claim 1 wherein the molten metal is a permanently grain refined alloy.
4. A method as defined in claim 1 including the steps of forming an annular entrapment recess above the shot chamber, and trapping an outer portion of the semi-solid slurry within the shot chamber within the entrapment recess in response to upward movement of the shot piston.
5. A method as defined in claim 1 wherein the molten metal is cooled within the shot chamber to a temperature range which produces a range of 40% to 60% solid to form the semi-solid slurry.
6. A method as defined in claim 1 wherein the molten metal is A356 aluminum alloy and is cooled within the shot chamber to a temperature within the range of 570°C to 590°C to form the semi-solid slurry.
7. A method as defined in claim 1 and including the step of directing the molten metal into a second shot chamber receiving a second shot piston, interchanging the second shot chamber and piston with the first shot chamber and piston after the semi-solid slurry is transferred from the first shot chamber into the die cavity, and cooling the molten metal within the second shot chamber to within the temperature range forming the semi-solid slurry.

8. A method as defined in claim 1 wherein the molten metal is cooled within a shot chamber having a diameter larger than its axial length.

9. A method as defined in claim 1 wherein the molten metal is cooled to form a semi-solid slurry within a shot chamber having a diameter of at least six inches.

10. A method as defined in claim 1 wherein the molten metal is A356 aluminum alloy and is cooled within the shot chamber to a temperature within the range of 570°C to 590°C to form the semi-solid slurry.

11. A method as defined in claim 1 wherein the gate opening is located to receive the semi-solid slurry within only a center portion of the shot chamber and to avoid receiving more solid slurry within an outer portion of the shot chamber.

12. A method of producing a high strength aluminum alloy part within a die cavity defined by a die set mounted on a vertical die cast press including a shot chamber having a generally vertical axis and a shot piston movable axially within the chamber, the method comprising the steps of heating an ingot of aluminum alloy to form a molten aluminum alloy having a grain refiner, directing the molten aluminum alloy into the shot chamber, cooling the molten aluminum alloy within the shot chamber to within a temperature range forming a semi-solid slurry having a globular and generally non-dendritic microstructure, moving the shot piston upwardly to transfer the semi-solid slurry from the shot chamber through a gate opening into the die cavity, and allowing the semi-solid slurry to solidify within the die cavity to form the aluminum alloy part.

13. A method as defined in claim 12 including the steps of forming an annular entrapment recess above the shot chamber, and trapping an outer portion of the semi-solid slurry within the shot chamber within the entrapment recess in response to upward movement of the shot piston.

14. A method as defined in claim 12 wherein the molten aluminum alloy is cooled within the shot chamber to a temperature range which produces a range of 40% to 60% solid to form the semi-solid slurry.

15. A method as defined in claim 12 wherein the molten aluminum alloy is A356 aluminum alloy and is cooled within the shot chamber to a temperature within the range of 570°C to 590°C to form the semi-solid slurry.

16. A method as defined in claim 12 wherein the gate opening is located to receive the semi-solid slurry within only a center portion of the shot chamber and to avoid receiving more solid slurry within an outer portion of the shot chamber.

17. A method as defined in claim 12 and including the step of directing the molten aluminum alloy into a second shot chamber receiving a second shot piston, interchanging the second shot chamber and piston with the first shot chamber and piston after the semi-solid slurry is transferred from the first shot chamber into the die cavity, and cooling the molten aluminum alloy within the second shot chamber to within the temperature range forming the semi-solid slurry.

18. A method as defined in claim 12 wherein the molten aluminum alloy is cooled within a shot chamber having a diameter substantially larger than its depth.

19. A method as defined in claim 12 wherein the molten aluminum alloy is cooled to form a semi-solid slurry within a shot chamber having a diameter of at least six inches.

20. A method as defined in claim 10 wherein the molten aluminum alloy is cooled within the shot chamber to a temperature within the range of 570°C to 590°C to form the semi-solid slurry.

21. A method of producing a high strength metal alloy part within a die cavity defined by a die set mounted on a vertical die cast press including a cylindrical shot chamber having a generally vertical axis and a shot piston movable axially within the chamber and wherein the diameter of the shot chamber is greater than an injection stroke of the shot piston, the method comprising the steps of heating a solid metal alloy to form a molten metal alloy, directing the molten metal alloy into the shot chamber, cooling the molten metal alloy within the shot chamber to a temperature within a predetermined temperature range to form a semi-solid slurry having a globular, and generally non-dendritic microstructure, moving the

shot piston upwardly to transfer the semi-solid slurry from the shot chamber through a gate opening into the die cavity, and allowing the semi-solid slurry to solidify within the die cavity to form the metal alloy part.

22. A method as defined in claim 21 and including the step of adding a grain refiner material to the molten metal alloy directed into the shot chamber.

23. A method as defined in claim 21 including the steps of forming an annular entrapment recess above the shot chamber, and trapping a an outer portion of the semi-solid slurry within the shot chamber within the entrapment recess in response to upward movement of the shot piston.

24. A method as defined in claim 21 wherein the molten metal alloy is cooled within the shot chamber to a temperature range which produces a range of 40% to 60% solid to form the semi-solid slurry.

25. A method as defined in claim 21 wherein the molten metal alloy is A356 aluminum alloy and is cooled within the shot chamber to a temperature within the range of 570°C to 590°C to form the semi-solid slurry.

26. A method as defined in claim 21 and including the step of directing the molten metal alloy into a second shot chamber receiving a second shot piston, interchanging the second shot chamber and piston with the first shot chamber and piston after the semi-solid slurry is transferred from the first shot chamber into the die cavity, and cooling the molten metal alloy within the second shot chamber to within the predetermined temperature range to form the semi-solid slurry.

27. A method as defined in claim 21 wherein the molten metal alloy is cooled to form a semi-solid slurry within a shot chamber having a diameter of at least six inches.

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FIG-1

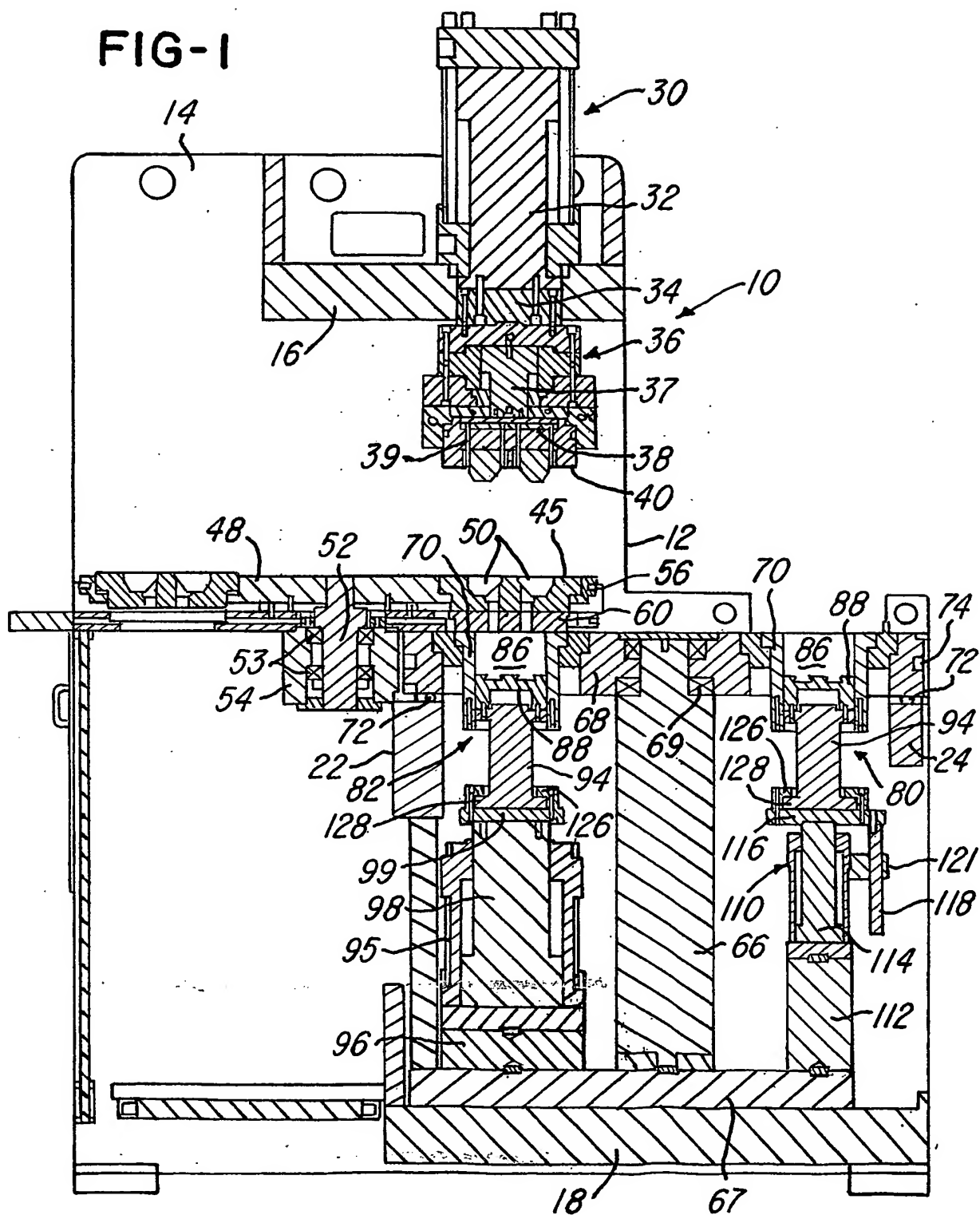


FIG-2

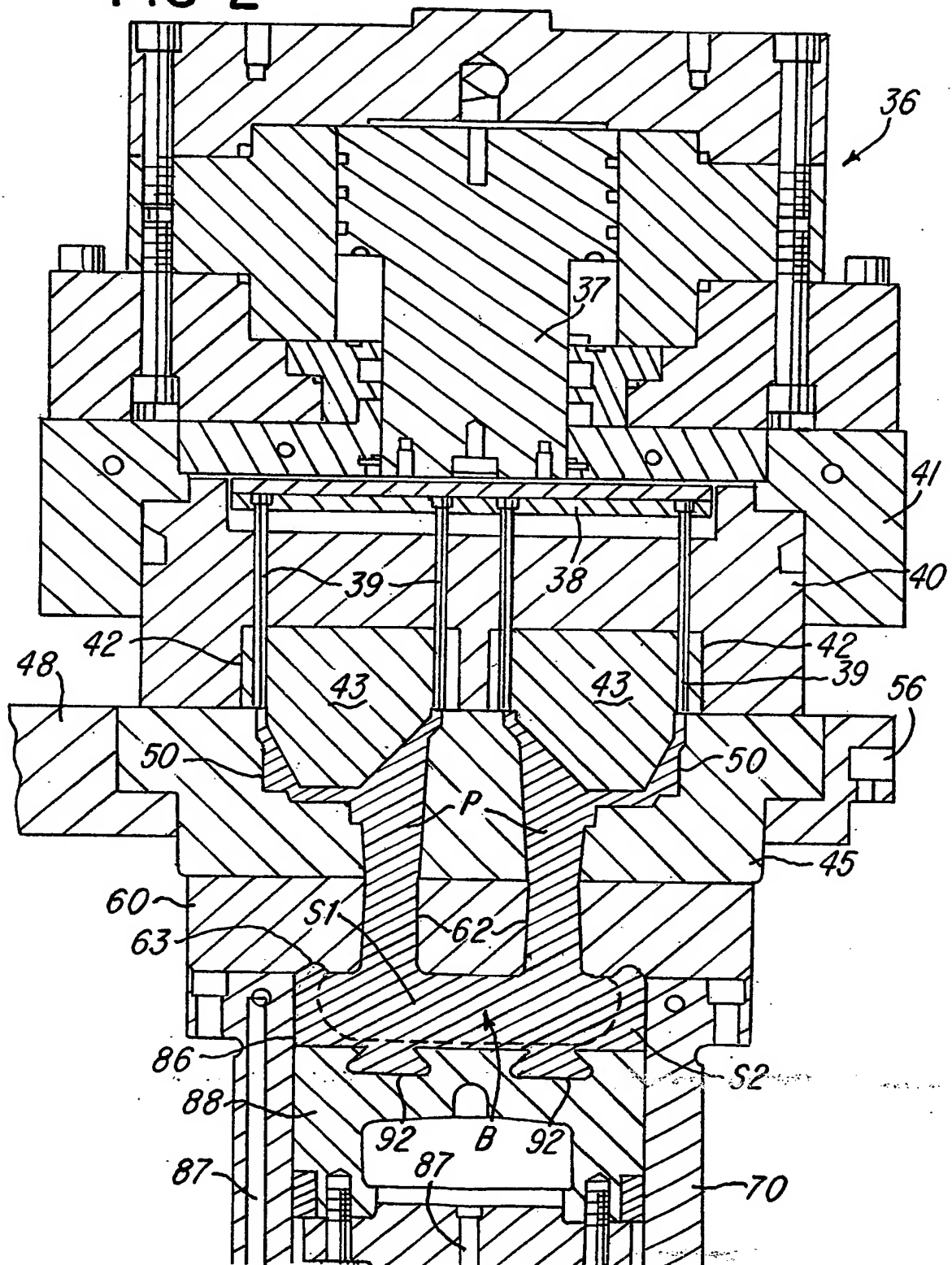
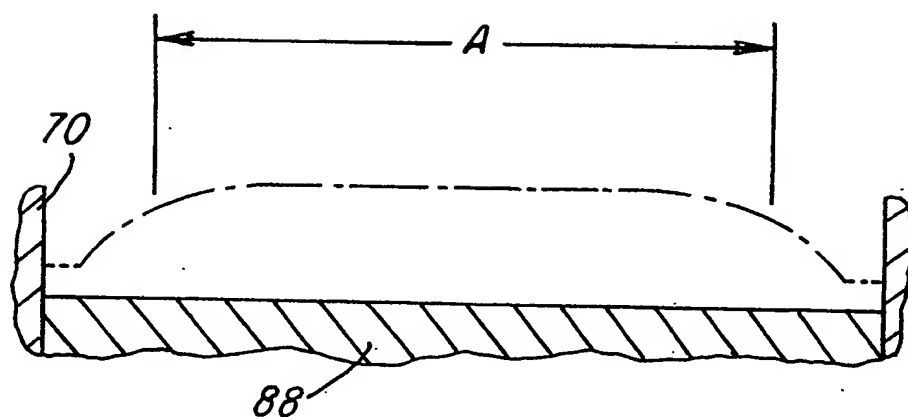


FIG-3



INTERNATIONAL SEARCH REPORT

International application No.

PCT/US02/37543

A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) : B22C 9/00
US CL : 164/900, 113

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
U.S. : 164/900, 113, 312

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X --- Y	WO 99/00203 A1 (HITACHI METALS LTD) 07 January 1999 (07.01.99), abstract and Figures 1, 5, and 6.	1,5 1,5,7-9,21,24,26,27
X --- Y	US 6,068,043 A (CLARK) 30 May 2000 (30.05.00), Figures 1, 2a-2c, column 1, lines 20-29, column 2, lines 54-67, column 3, lines 1-9, 18-37, column 4, lines 11-21.	1,7 1,5,7-9,21,24,26,27
Y	US 5,660,223 A (THIEMAN et al) 26 August 1997 (26.08.97), Figure 2, column 1, lines 5-59.	1,5,7-9,21,24,26,27
Y	JORSTAD, Science and Technology of Semi-Solid Metal Processing, Chapter 4 "Processing of SSM: Practical Considerations", North American Die Casting Association, October 2001, pages 1-20, especially pages 2, 3, and 6.	3, 6, 10, 25
Y	US 5,730,201 A (RÖLLIN et al) 24 March 1998 (24.03.98), Figure 1, column 1, lines 4-11, column 2, lines 34-63, column 3, lines 8-48, column 5, lines 16-31, column 6, lines 22-40, column 7, lines 14-20.	4, 11, 13, 16, 23



Further documents are listed in the continuation of Box C.



See patent family annex.

Special categories of cited documents:	
"A" document defining the general state of the art which is not considered to be of particular relevance	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"E" earlier application or patent published on or after the international filing date	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
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"O" document referring to an oral disclosure, use, exhibition or other means	"&" document member of the same patent family
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Date of the actual completion of the international search

19 February 2003 (19.02.2003)

Date of mailing of the international search report

26 MAR 2003

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Form PCT/ISA/210 (second sheet) (July 1998)

INTERNATIONAL SEARCH REPORT

PCT/US02/37543

C.. (Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	EP 0 554 808 A1 (EFU GES FUER UR UMFORMTECHNIK) 11 August 1993 (11.08.93), abstract.	2, 12, 14, 15, 17-20, 22
A	US 5,579,825 A (SHIBATA et al) 3 December 1996 (03.12.96), Figure 1.	1-27

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US02/37543

Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This international report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claim Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claim Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
3. ☐ Claim Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of Item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

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The additional search fees were accompanied by the applicant's protest.

No protest accompanied the payment of additional search fees.

Form PCT/ISA/210 (continuation of first sheet(1)) (July 1998)